

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021898**Date Inspected:** 13-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #16

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW)

Weld joint 019 Located on Crash Barrier W5-SB40-001. Welder is identified as 062092. ZPMC Quality Control Inspector (QC) is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-ESAB.

Weld joint- 079 Located on Crash Barrier W2-SB18-002. Welder is identified as 222396. ZPMC Quality Control Inspector (QC) is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint- 063, Located on Crash Barrier W5-SB37-001. Welder is identified as 048625. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld joint- 126 Located on Crash Barrier W5-SB42-001. Welder is identified as 201074. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint- 131 Located on Crash Barrier W5-SB31-005. Welder is identified as 201889. ZPMC Quality Control Inspector (QC) is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Shielded Metal Arc Welding (SMAW)

Weld joint- 003/004 Located on Crash Barrier E2-SB30-001. Welder is identified as 053753. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

Bay #19

Shielded Metal Arc Welding (SMAW)

Weld joint- 004 Located on Suspender Bracket SB 023-106 as per CWR no. B-CWR-2779. Welder is identified as 259566. ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-Repair.

Bay #14

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW)

Weld joint-41/42, Located on I rib to Side plate in Segment 14E, SEG 3019C. Welder is identified as 066236. ZPMC Quality Control Inspector (QC) is identified as Zhu feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB

Shielded Metal Arc Welding (SMAW)

Weld joint-100, Located on Side plate to Side plate, SEG 3019AW. Welder is identified as 070007. ZPMC Quality Control Inspector (QC) is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-FCM-1.

Weld joint-323, as per CWR no. B-CWR 2677 Located between Floor beam to Bottom plate, SEG 3019D-1. Welder is identified as 201087. ZPMC Quality Control Inspector (QC) is identified as Zhan Hai Feng. The

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

welding variables recorded by QC appeared to comply with the WPS-345-SMAW- 2G (2F)-FCM- Repair..

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
